

Date: Thursday, 7/5/2007 8:15:55 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG EXTRUSION
Job Number	: 33310		
Estimate Number	: 10305		
P.O. Number	: N/A	Part Number	: D2423
This Issue	: 7/5/2007 S.O. No. : N/A	Drawing Number	: D2423 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: B1
Previous Run	: 30062	Material	: N/A
Written By	:	Due Date	: 8/12/2007
Checked & Approved By	: <u>AD 07.07.05</u>	Qty:	360 Um: Each
Comment	: Est G 04.09.02 Part Number D2423-108 changed to D2423 K J/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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2.0	D2423P	Lug Extrusion
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Comment: Qty.: 1.0000 f(s)/Unit Total : 360.0000 f(s)

Lug Extrusion

P/O: 4104 C207107105 (360FT)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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4.0	QC6	DIMENSIONAL CHECK
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5.0	PACKAGING 1	PACKAGING RESOURCE #1
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6.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07/08/10

Job Completion



C207108110

62

Num 07/09/25

I.D and stock material.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 07/01/10
 QA: N/C Closed: _____ Date: _____

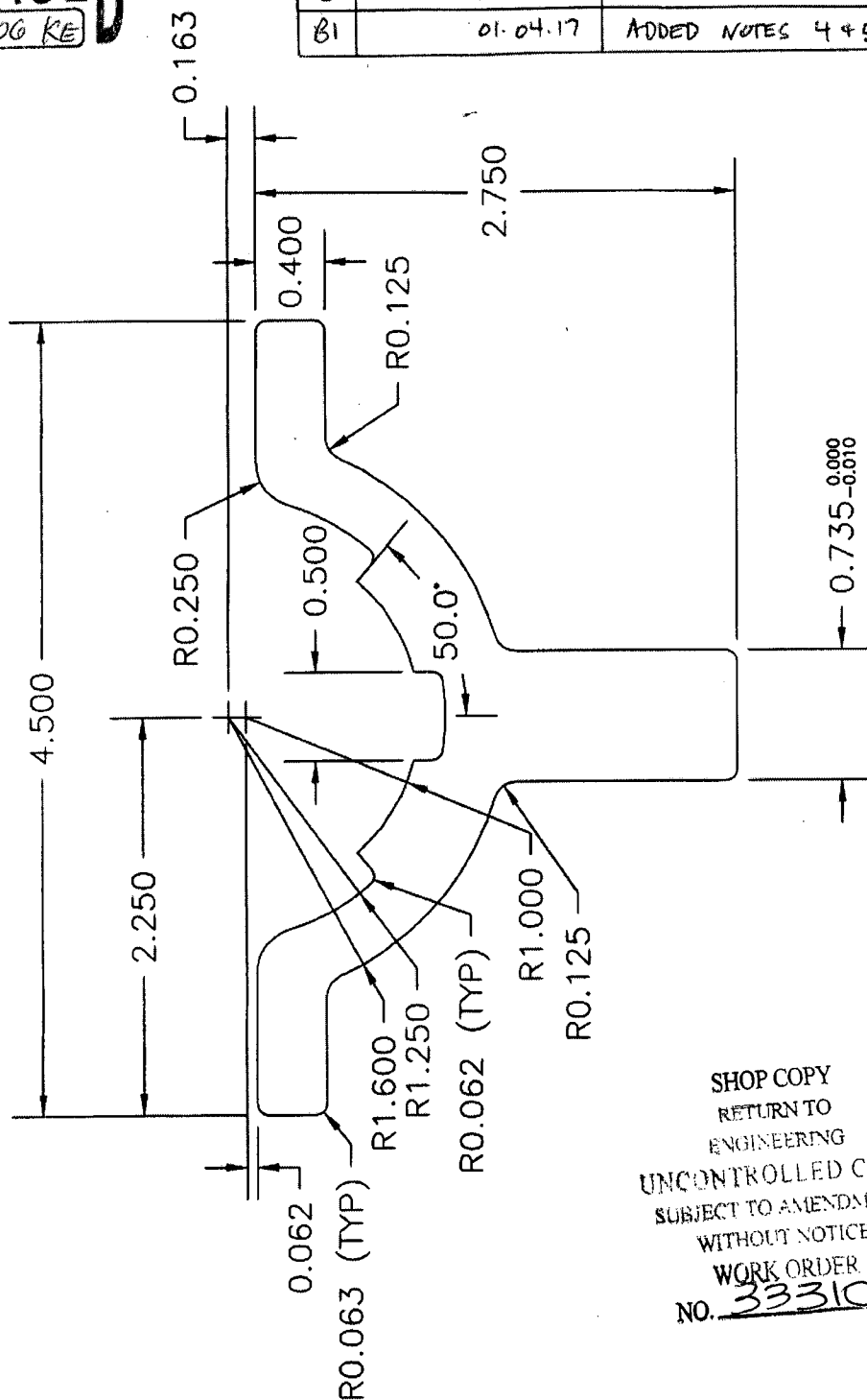
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. . D2423	REV. B SHEET 1 OF 1
DATE 98.08.04		TITLE LUG EXTRUSION	SCALE 1:1
A	95.05.09	NEW ISSUE	
B	98.08.04	6061-T6 WAS 6005A.T5	
B1	01.04.17	ADDED NOTES 4 & 5 # CP	

RELEASED
98/08/06 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33310

1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARBIDE INDEX DIE # MS-18866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



INDALEX LIMITÉE
325 RUE AVRO
POINTE-CLAIRE (QUÉBEC) H9R 5W3
TÉL.: 514-697-5120 • FAX: 514-694-8310

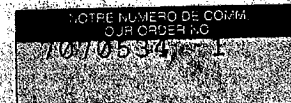
PROFILÉS D'ALUMINIUM - ANODISATION - FABRICATION - PEINTURE
ALUMINUM EXTRUSIONS - ANODIZING - FABRICATION - PAINTING

P/S#: 613841

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONT

EXPÉDIÉ / SHIP TO

INDICATIONS SPÉCIALES
SPECIAL INSTRUCTIONS



MÊME - SAME

K6A1K7

CUSTOMER P.S.T. : *6122-5207

INDALEX G.S.T. REG NO: R136834041

Required Date:

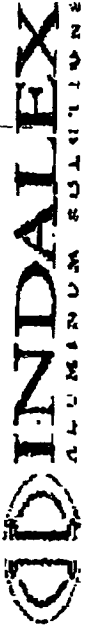
DU CLIENT ST. NO.	TPS G.S.T.	TAXE DE VENTE PROV. PROV. SALES TAX	N° DE COMM. DU CLIENT CUST. ORDER NO.	DATE DE COMMANDE ORDER DATE	NOTRE DATE DE COMM. OUR ORDER DATE	CONDITIONS TERMS
201355	XXXXXX			1/07/06	1/07/06	

VOEUR LES MAN	EXPÉDIÉ PAR SHIP VIA	PAYÉ PRO	PERC. GOL	C.A.D. C.O.D.	F.A.B. F.O.B.	EN BALLOTS BUNDLED AND TAPED	CARTONNÉ CARTONED	CARTONNÉ & INTERCALÉ CARTONED & INTERLEAVED
51	NOTRE CAMION OUR TRUCK							

DATE DE LIVRAISON DATE SHIPPED	ENVOYÉ PAR SHIPPED VIA
1/07/19	OTTAWA 20 JUIL

COMMANDE ORDERED		CETTE EXPÉDITION THIS SHIPMENT			MONTANT AMOUNT
POIDS WEIGHT	PIECES PIECES	BALLOTS BDLES	POIDS WEIGHT	PIECES PCS	
1	622	40	MS	18866 D2423P	6061 T6 2743
F EXTRUDE ONLY					
DUE=2007/07/31 07-31					
LUG EXTRUSION					
BUNDLE= 774736 774744					
We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures					
ISO 9001					
5 Fusion					

FEUILLE D'EMPAQUETAGE



325 rue Avro
Pointe-Claire QC H9R 5W3
Téléphone (514) 697-5120
Fax-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD
Adresse / Address : 1270 ABERDEEN STREET
HAWKESBURY ONT;
K&A 1K7
commande Indalex / Indalex order #: 7070534
bon de commande / Purchase order #: 4104
de matrice / Die #: MS 18856 Description: LUG-EXTRUSION
Alliage & trempage / Alloy & temper: 6061 T6
Contrôle / Control #: 50092-1
Coulée / Cast #: 40861

	Min. requis Min. required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	42725
Contrainte élastique Yield stress (psi)	35 000	40142
% élongation dans 2" % elongation in 2"	8	12
% élongation in 2" Barett Rockwell E (Hn) Rockwell E Hardness (Hn)	88 @ 100	92

Composition chimique typique / Typical chemical composition:

	Si	Fe	Cu	Mn	Mg	Cr	Zn	P
6061	0.20 - 0.60	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
6005	0.60 - 0.90	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
6061A	0.48 - 0.72	0.15 - 0.27	0.08 - 0.12	0.20 - 0.24	0.48 - 0.52	0.03 Max	0.05 Max	0.03 Max
6061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max
6351	0.7 - 1.5	0.5 Max	0.10 Max	0.40 - 0.80	0.40 - 0.80	--	0.20 Max	0.20 Max

Nous certifions que le matériel fourni répondre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AMS QQA 200/8 exceptés pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and AMS QQA 200/8 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre,
Yours truly,

date : 2007-07-18

Mark Oliver Koklong
Technicien de la qualité
Quality technician

Indalex Limited

1	HZ	K6	CUS	NO DU CLIENT	20	SALESMAN	ITEM NO.	COA	PO	WEI	1	5	We here Chemical Associat	HFH 00/60
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